Model 79-3500 Weld Head
Troubleshooting Guide

M79-3500 Weld Head		
Travel Problems	***Possible Problem Area***	***Solutions***
Travel Stops (no Jog)	Broken wire in control cable	Check connectors for broken connection, check control cable for damage
Travel Stops (no Jog)	Broken motor	Replace motor with rebuilt
Travel stops (Jog motor turns but no movement)	Broken motor	Coupling and sheer pin
Travel not in control in sequence (jog like speed)	Broken adjustment trim pot	Replace
Travel not in control in sequence	Broken wire to motor	Repair wire connection
Travel not in control in Weld Sequence but Ok in Test	Shorted feed back wiring to Weld Head housing	Repair shorted wire
Travel slow	Low high-pot for motor	Replace motor with rebuilt
AVC Problems		
AVC Travel stops (no Jog)	Broken wire in control cable	Check connectors for broken connection, check control cable for damage
AVC Travel stops (no Jog)	Broken motor	Replace motor with rebuilt
AVC Travel rough	Loose clutch	Repair and adjust clutch spring pressure
AVC jogs up at sequence start	Broken power cable	Replace wire rope and fittings
AVC jogs down only at touch start	Broken or not connected ground	Connect ground
RF Problems		
No RF start at sequence start	Broken power cable	Replace wire rope and fittings
No RF start at sequence start	Zipper wrapped around pipe	Unwrap cable assembly from pipe
No RF start at sequence start	Broken choke	Replace choke
OSC Problems		
OSC Travel stops (no Jog)	Broken wire in control cable	Check connectors for broken connection, check control cable for damage
OSC Travel stops (no Jog)	Broken motor	Replace motor with rebuilt
OSC Travel stops (Jog motor turns but no movement)	Broken motor	Coupling and sheer pin
OSC Travel Stops (Jog motor turns but no position control)	Broken feed back potentiometer	Replace position pot
OSC Drifts to one side	Feed 5 volts wire broken	Repair wire connection
OSC Travel rough	Dirty Ball Screw	Clean and lubricate with dry lube
OSC Travel rough	Damaged Ball Screw	Replace Ball Screw Assembly
Wire Feed Problems		
Wire Feed Stops (no Jog)	Broken wire in control cable	Check connectors for broken connection, check control cable for damage
Wire Feed Stops (no Jog)	Broken motor	Replace motor with rebuilt
Wire Feed (Jog motor turns but no movement)	Broken motor	Coupling and sheer pin
Wire Feed not in control in Sequence	Broken Adjustment Trim Pot	Replace
Wire Feed not in control in Sequence	Broken wire to motor	Repair wire connection
Wire Feed not in control in Weld Sequence but OK in Test	Shorted feed back wiring to Weld Head housing	Repair shorted wire

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